

Date: Monday, 11/6/2006 2:39:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG EXTRUSION		
Job Number	: 29339					
Estimate Number	: 10326					
P.O. Number	: N/A			Part Number	: D27317	
This Issue	: 11/6/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2731 REV B	
First Issue	: 11/6/2006		Type	: MACHINED PARTS		
Previous Run	: 28936			Project Number	: N/A	
Written By	: <u>DK</u> 06/11/07			Drawing Revision	: B	
Checked & Approved By	: <u>DK</u> 06/11/07			Material	: N/A	
Comment	: Est D 00.95.19 Added inspect level 8, removed P/O powder coating EC			Due Date	: 11/22/2006	
				Qty:	100	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
	Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: <u>B23779</u>	J.F. 06/11/07 102
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut D2423 extrusion to .82"	Batch <u>B23779</u> J.F. 06/11/07 102
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 Issue P.O 2438 102 Machine per drawing D2731 Rev B
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling	
4.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE
		 Receive & suspect for transit damage 102
5.0	QC5	SECOND CHECK
		 Comment: SECOND CHECK Inspect level 5 102

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: TP Date: 06/11/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 29339

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



qc.



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YL 06/11/22 X 102

7.0 POWDER COATING

POWDER COATING



qc.



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

YL 06/11/27 X 102

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *S448*

PL 6/11/28 102

10.0 QC21

FINAL INSPECTION/W/O RELEASE



102

Comment: FINAL INSPECTION/W/O RELEASE

PL 6/11/29

Job Completion



6/6/11/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA		
CHECKED <i>KE</i>	APPROVED <i>JK</i>	DRAWING NO. D2731	REV. B	SHEET 1 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE	1:1
A	98.05.13	NEW ISSUE		
B	99.07.06	REVISED DIMENSIONS		

4.450

SYMMETRIC ABOUT φ

MACHINE TO SIZE

0.100 (REF)

0.157

R0.125

D2731-1

1.91 (REF)

0.306

0.345

0.400

0.250

0.735 (REF)

R1.250 (REF)

R1.000 (REF)

ENGRAVE PART NUMBER
TO DEPTH OF 0.010 ± 0.005
IN THIS LOCATION, WITH TOOL
TIP RADIUS OF 0.015 ± 0.005

RELEASED
09.07.14 KE

R0.375

Technical drawing showing a cross-sectional view of a mechanical part. The part has a total width of 3.700. A central feature has a diameter of $\phi 0.257^{+0.005}_{-0.000}$ (TYP). The distance from the center of this feature to the right edge is 0.750. The top edge has a fillet of R0.375 (REF). A dimension of 0.375 is also present. The drawing includes a reference line with a plus sign and a coordinate system with a plus sign. The text "D2731-1" is at the bottom. The right side of the drawing includes the text "SHOP COPY", "RETURN TO", and "ENGINEERING" vertically, and "UNCONTROLLED" at the bottom.

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29339



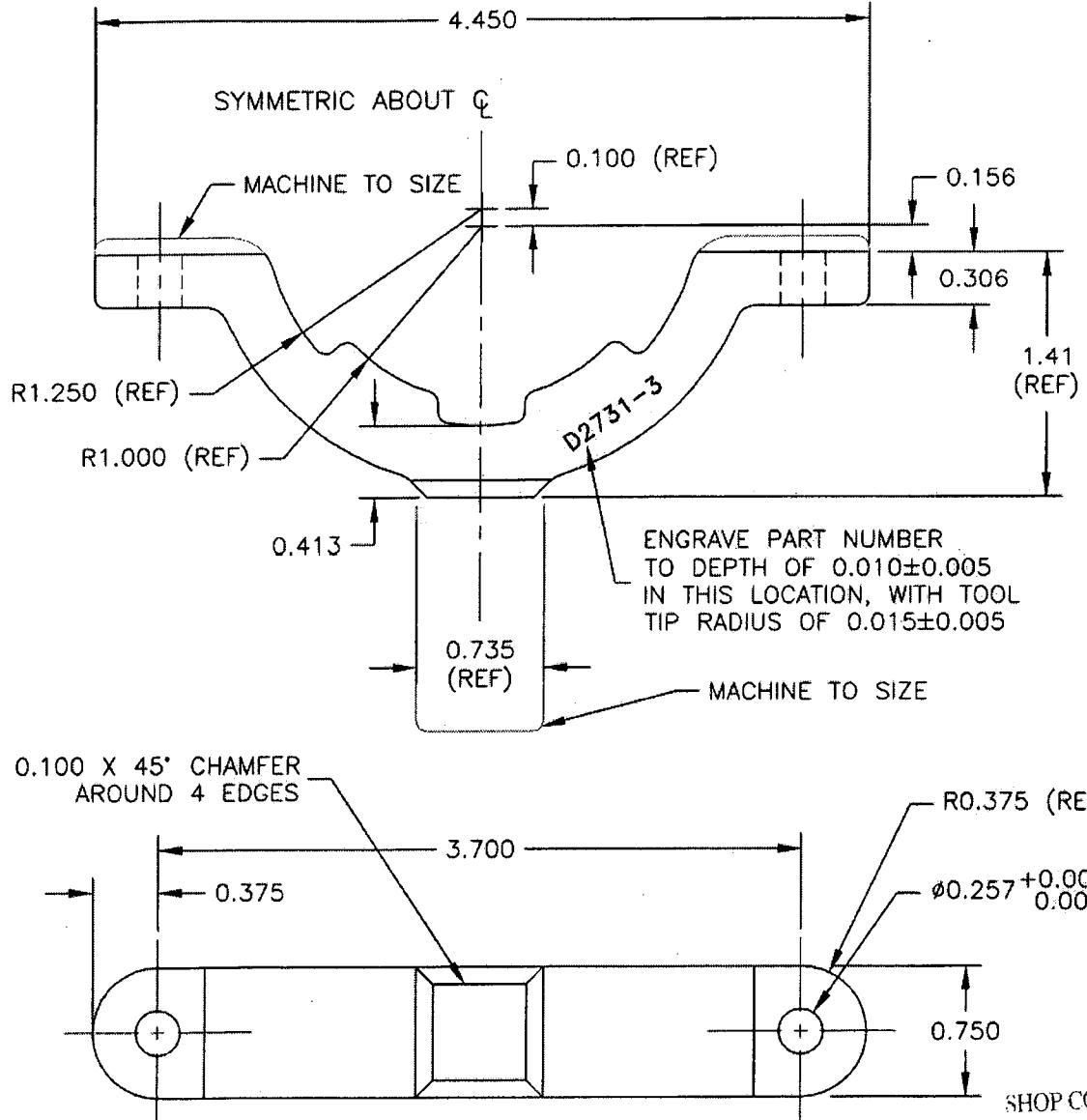
DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		TITLE MOUNTING LUG

REV. B

SHEET 2 OF 4

SCALE

1:1

RELEASED
19.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

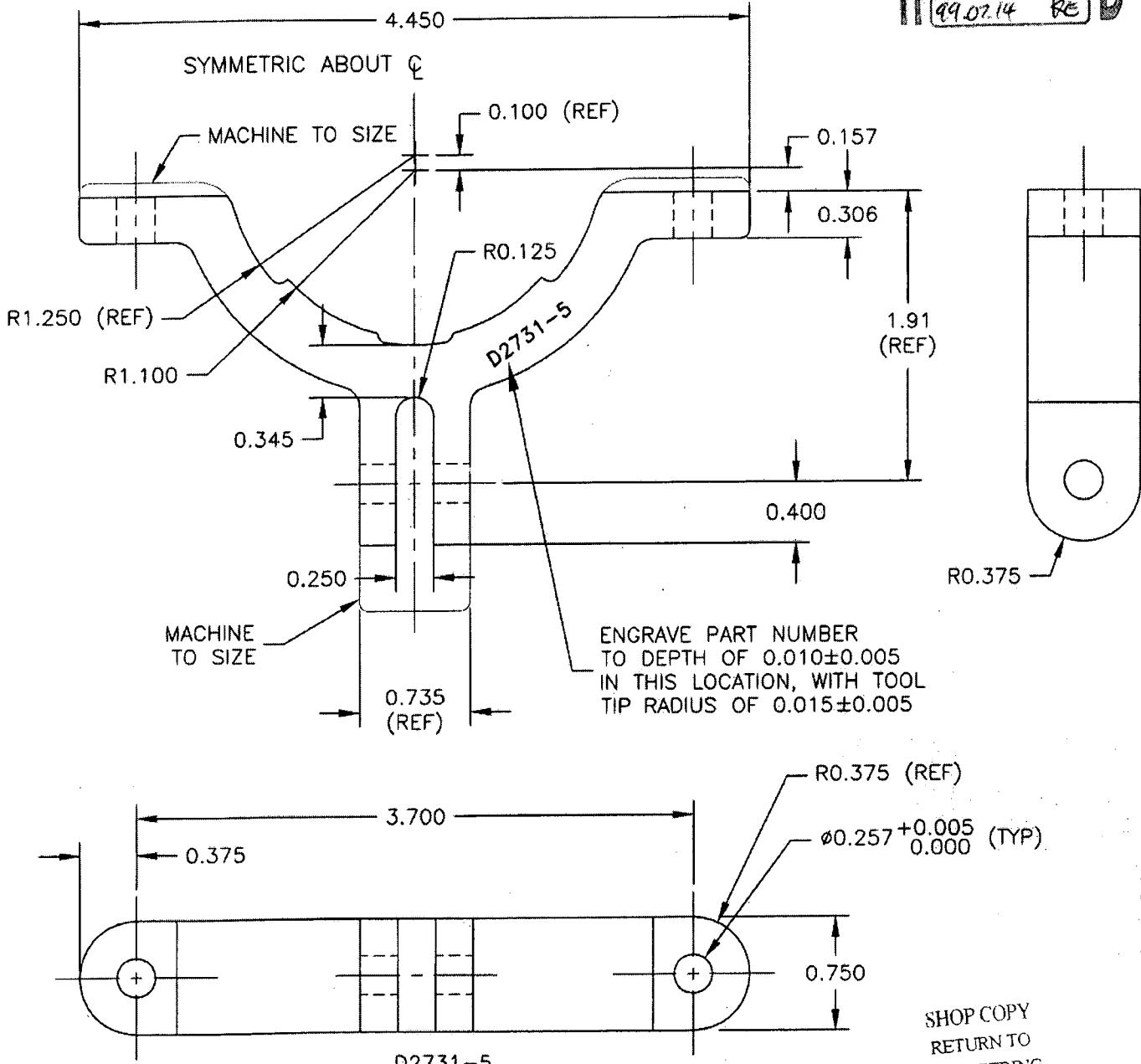
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29339



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>VS</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
99.07.14 RE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

FINISH: ACID ETCH AND ALCUDINE PER DART QSI 005 .1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005

POWDER COAT WHITE (4.3.5.1) PER DART QSI 003 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED. NO. 29

NOTE: The following table is a summary of the data presented in the main report. It includes the total number of cases, the number of cases with known outcomes, and the percentage of cases with known outcomes for each category.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ATTENTION

SUBJECT TO AMENDMENT
BY NOTICE

WITHOUT NOTICE

4.3 WORK ORDER

4.5 WORK AREA
NOTED 28339

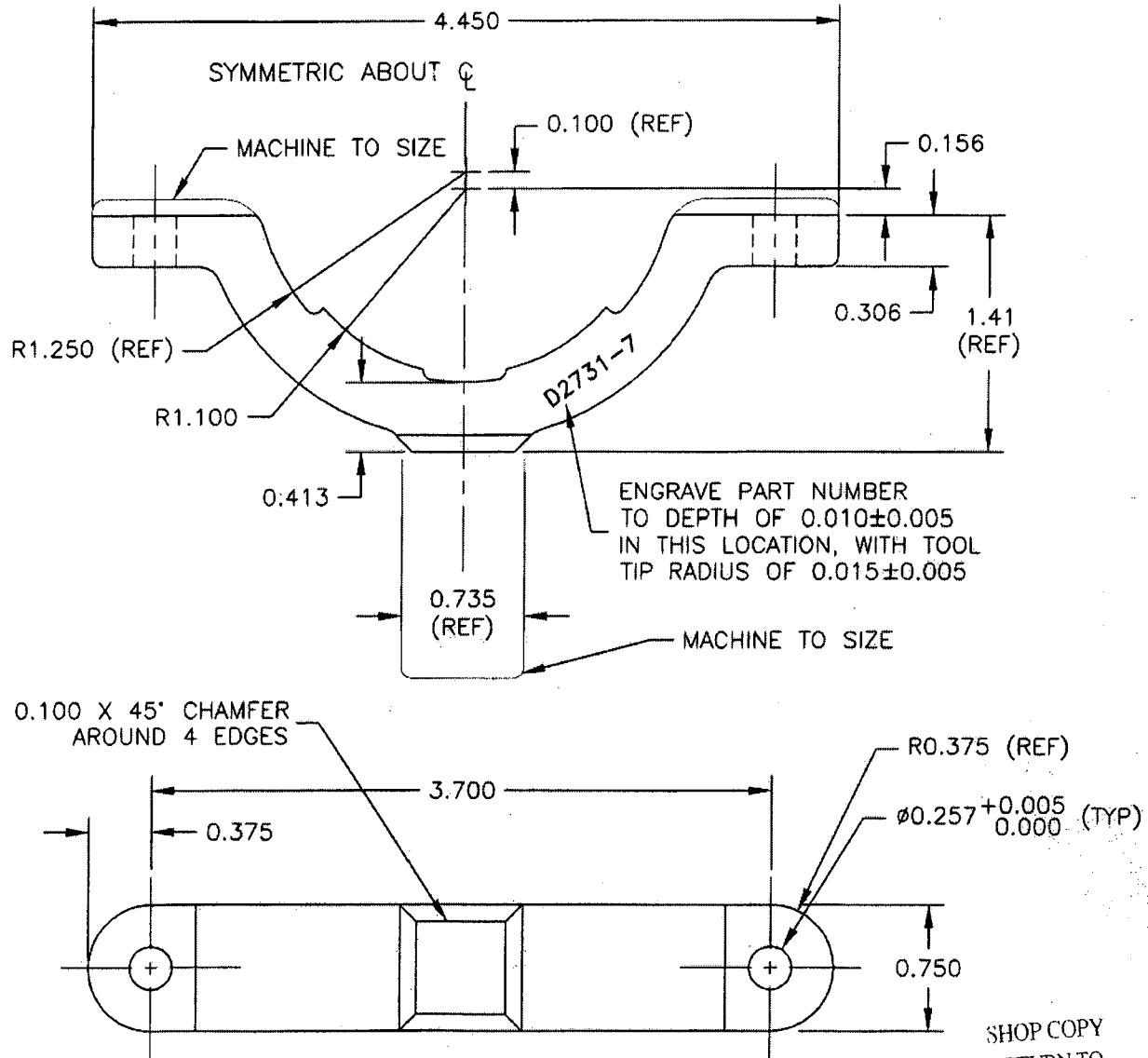
NOTED NO. 292

Notes



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>CD</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 SCALE 1:1

RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALLODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29339



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
102	D2731-7	Lug	2438

MATERIAL: supplied by DART B29339 D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi (Regula) Walz".

A handwritten signature in black ink, appearing to read "J".

Vankleek Hill, November 17, 2006